

Date: Monday, 12/01/2009 2:29:57 PM
User: Julie Dawson

Process Sheet

Black
Dart Aerospace Ltd.

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 44552		
Estimate Number	: 11044		
P.O. Number	:	Part Number	: D28105
This Issue	: 12/01/2009	S.O. No. :	<i>Sm/Fab</i>
Prsht Rev.	: NC	Drawing Number	: D2810 / D2727
First Issue	: / /	Project Number	: N/A
Previous Run	: 41676	Drawing Revision	: C / A1
		Type	: MACHINED PARTS
Written By	:	Material	:
Checked & Approved By	: <i>JLD 09.01.12</i>	Due Date	: 20/01/2009
Comment	: Est. A 04.11.30 New issue KJ/JLM	Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 2.1000 f(s)/Unit Total: 21.0000 f(s) *31.5*

304 RD Tube .500 x .035W

Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control

Dwg D2727 using Jig DT8012

Batch: *M10113*

SB 09/02/19 (15)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012

2-Deburr

M-1 09/02/19 (15X)

SB 09/02/19 15

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

20.02.19 (15)

4.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: *8:30am*

OVEN TEMPERATURE: *320°C*

FINISH TIME: *9:00am*

20-02-20 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:29:57 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 44552

Part Number: D28105

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



15

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fix 09/02/20

6.0

PACKAGING 1

PACKAGING RESOURCE #1



15K

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: JCS

9/2/20

50

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/23 JCS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

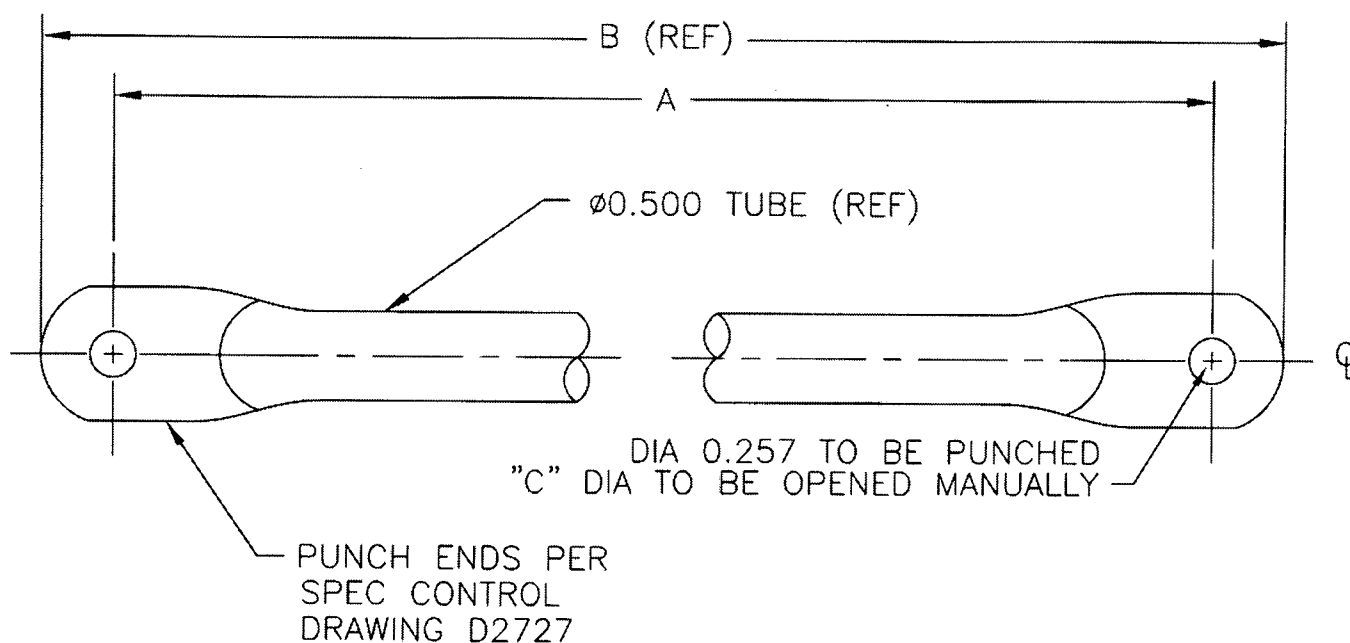
NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2810	REV. C SHEET 1 OF 1
DATE 04.11.22		TITLE STRUT	SCALE NTS
A	00.11.08	NEW ISSUE	
B	03.09.11	ADD FINISH	
C	04.11.22	ADD -5	

RELEASE

05-13-11



PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

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WORK ORDER
NO. *44552*

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.500 \times 0.035$ WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

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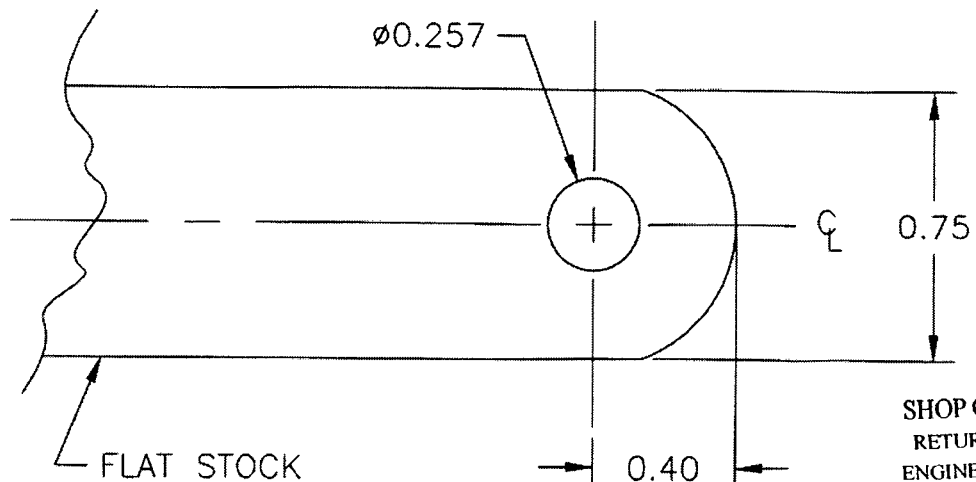
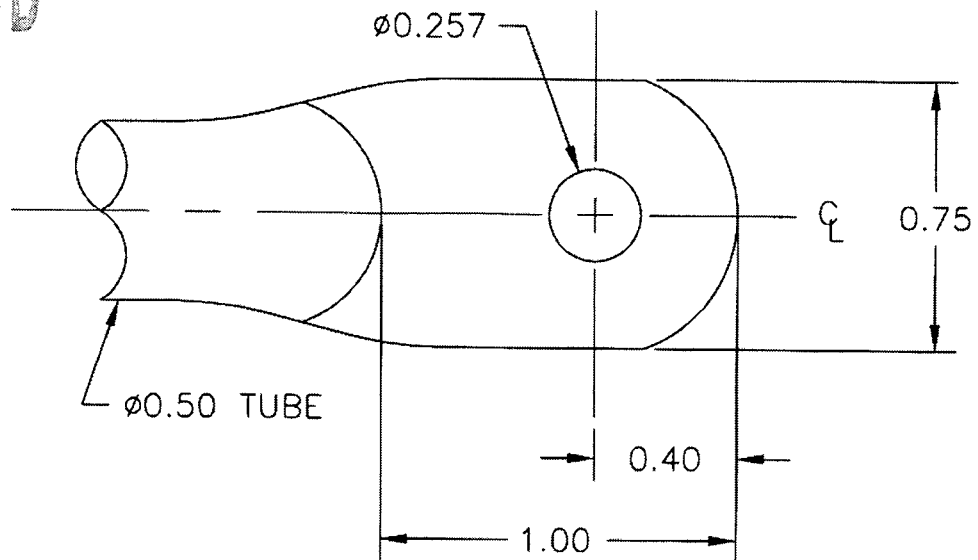
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED CA	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	12.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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